XX	A 1 .	TT	CCEEC
work	Urae	rw	66556

Page 1

Tuesday, February 22, 2011 9:21:42 AM

Item ID:

D3407-5

2/22/2011

QC:

Accept



Setup Start



Stop

Item Name: **Start Date:** 

**Revision ID:** 

Ring

Required Date: 2/25/2011

Start Qty: 20.00

Req'd Qty: 20.00

Date:



**Cust Item ID: Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date: //-02-22 Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID** 

Operation

**Revision Nbr** 

Description

Set Up/ **Run Hours**  Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Draw Nbr D3407

Rev E

100

Waterjet

FLOW CNC Waterjet

17-4 ,750x4.

FLOW WATER JET

Memo

1-Cut as per Dwg D3407

Dwg Rev: Prog Rev:

2-Break edges on grinder as per Dwg D3407

=) mid 11/00/24



110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC-

Quality Control

Memo

0.00

B11-2-27

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W/O:			WORK ORDER CHANGES											
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#### Work Order ID 66556

Tuesday, February 22, 2011 9:21:42 AM



Page 2

Item ID:

D3407-5

Accept



Date:

Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Ring

2/22/2011

**Start Oty: 20.00** 

Reg'd Oty: 20.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

0.00

Date:

Run

Start

Stop

Stop



Sequence ID/

**Required Date: 2/25/2011** 

Date: \_\_\_\_\_

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

SPC (Y/N):

Set Up/

**Run Hours** 

Tool # Plan

Accept Reject

Reject Number Stamp

Work Center ID 120

Quality Control

Operation Description

OC8- Inspect parts - second check

Memo

0.00 Sula 124

Tool ID

Code

Otv Qty

Insp.

130

Packaging

Packaging

Identify as per dwg & Stock Location: W/A

0.00

Memo

0.00

El 11-2-24

140

QC21- Final Inspection - Work Order Release

0.00

0.00

MF 11-02-24

Quality Control

Memo

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W/O:			W	ORK ORDER CHANG	GES						
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### **Picklist Print**

Tuesday, February 22, 2011 9:21:50 AM

Work Order ID: 66556

Parent Item: D3407-5

Parent Item Name: Ring

Start Date: 2/22/2011

Required Date: 2/25/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

**Comments:** 

IPP Rev:A New Issue 05-11-22 JLM

IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	6.6600	0.2666	5.612632			
										J.B.	(-2-53	<b>&gt;</b>	

17-4 SS Bar .250 X 4.00

 Location
 Loc Qty
 Loc Code

 MAT54
 6.66

 116835
 6.66

116835



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DATE	CTED	Description of NC		Corrective Action Section B			cation	ation Approval	Approval		
DATE	STEP Description of N	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	40554
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407 Rev: E		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	1760	صد		V 1802	
Ø3.000	+/-0.030	2.996	D		V	
Ø2.050	+0.012/-0.001	2.651	×		V	
0.75	+/-0.030	756	Ä		V	
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Measured by:	1B	Audited by:	2	Prototype Approval:	N/A
Date:	11-9-93	Date:	40224	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM	
В	07.09.18	Tolerance revised	KJ/EC	
С	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM ,	1
D	09.05.04	Dwg Rev updated	KJ/DD	5/2/

Dart Aerospace Lt
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<sup>•</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY RETURNTO ENGINEERING UNCONTROLLED COPY QTY -041 QTY PART NUMBER DESCRIPTION -043 SUBJECT TO AMENDMENT X D3407-041 **TOW RING** D3407-043 **TOW RING** WITHOUT NOTICE D3407-045 **TOW RING** D D3407-1 STEM D3407-3 STEM D3407-5 RING STEM D3407-7 -D3407-5 RING -D3407-5 RING D3407-5 RING 8 [8] 8 E -D3407-1 STEM -D3407-3 STEM D3407-7 STEM **D3407-041 TOW RING D3407-043 TOW RING D3407-045 TOW RING △** ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY 08.07.23 D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY 08.04.07 С -1/-3 LONGER FOR FIT W/WASHER 05.09.09 В UPDATE DIAMETER, THREAD CLASS ADDED 05.06.17 NEW ISSUE Α 05.03.16 REV. DESCRIPTION DATE NOTES: 1) MATERIAL: N/A DESIGN DART AEROSPACE USA. INC. DRAWN PORT HADLOCK, WA 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS) 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED CHECKED DRAWING NO. REV. E D3407 4) UNITS: INCHES UNLESS OTHERWISE NOTED MFG. APPR. SHEET 1 OF 5 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING APPROVED TITLE SCALE **TOW RING** DE APPR.

8

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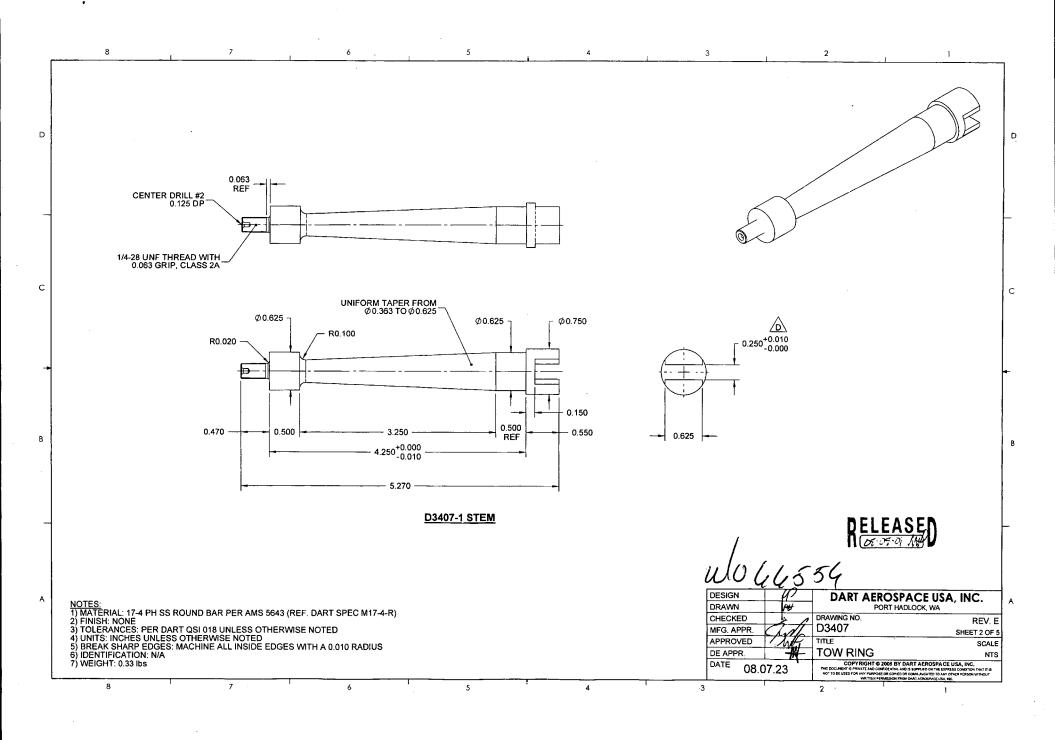
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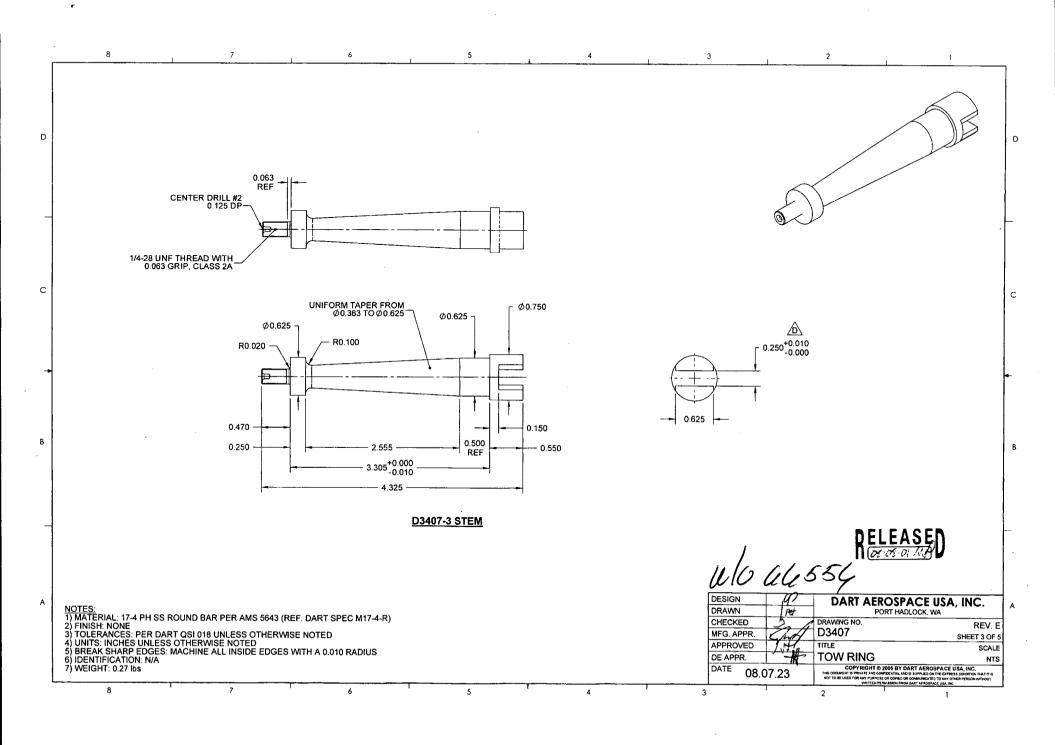
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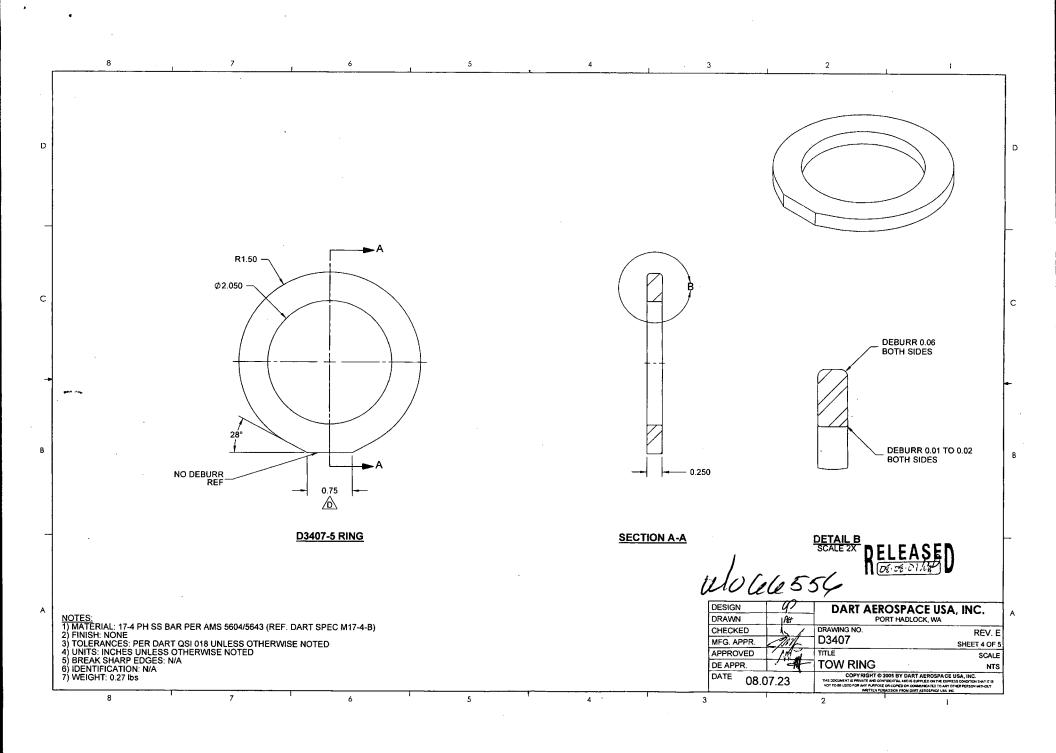
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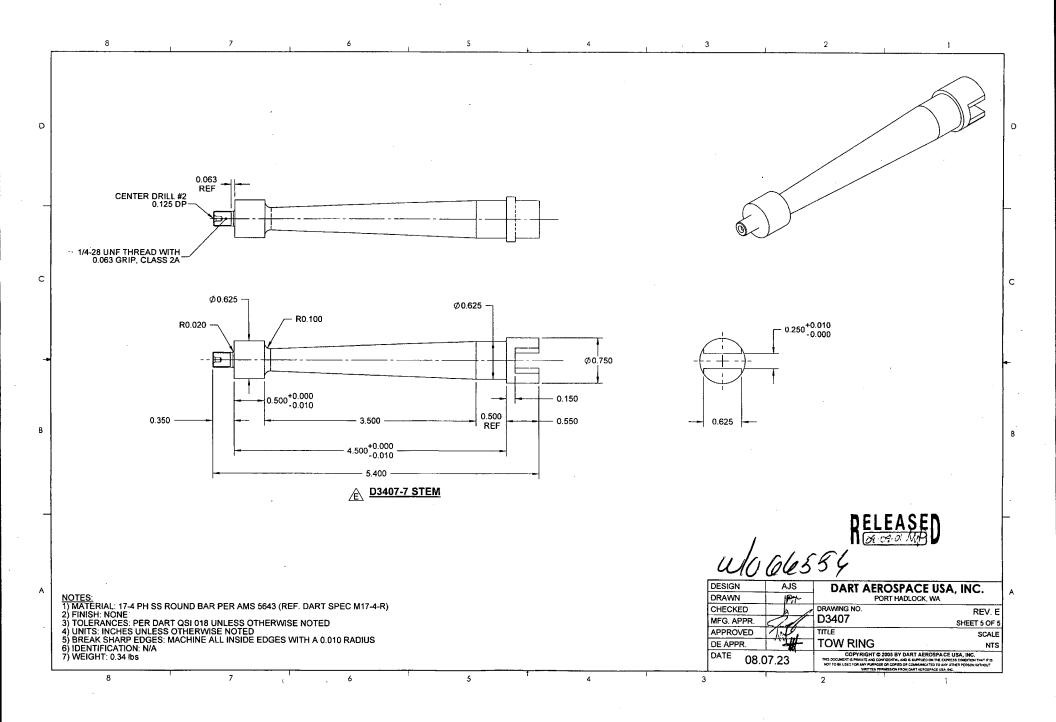
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